

Date: Wednesday, 13/12/2006 10:01:18 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 29914	
Estimate Number : 11066	
P.O. Number : <i>N/A</i>	Part Number : D2945
This Issue : 13/12/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2945REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 29352	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 22/12/2006 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est B 00.01.27 Added inspect level 8, removed P/O for powder coating EC Est Rev:C Now on Waterjet 06-12-13 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0187X04000

6061-T6 Bar .178" x 4.0"



5.9667



Comment: Qty.: 0.2712 f(s)/Unit Total : 5.4243 f(s)

6061-T6 Bar .178" x 4.0"

Material: 6061-T6 (QQ-A-250/11)4.00" x 0.188" thick

Batch No. *m101417*

ml 06 12 18

(20)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2945

Dwg Rev: *A*

Prog Rev: *A*

ml 06 12 18

(20)

2-Deburr if necessary

SAD 06.12.18

(19)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 06 12 18



(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



(PTC)






Comment: SECOND CHECK

12/12/18

(19)

oc

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/12/18	4	1 part scrap When cutting on water jet part moved	 06/12/18	destroy part & replace.	 06-12-18	 06/12/18	 06/12/18	 06/12/18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 07.01.05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 13/12/2006 10:01:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 29914

Part Number: D2945

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

im

FL/a.m 06/12/28

(20)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

im 06/12/28

(20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m / ER

06/12/29

(20)

8.0

PACKAGING 1.

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51396*

07/01/04

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107.01.05

Job Completion



07-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

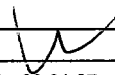
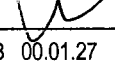
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 13/12/2006 9:54:32 AM
 User: Linda Lacelle









Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 29352	
Estimate Number : 11066	
P.O. Number :	Part Number : D2945
This Issue : 13/12/2006 S.O. No. :	Drawing Number : D2945REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 06/11/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By : 	Due Date : 15/11/2006 Qty: 20 Um: Each
Checked & Approved By : 	
Comment : Est B 00.01.27 Added inspect level 8, removed P/O for powder coating EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
		
Comment: Qty.: 0.2712 f(s)/Unit Total : 5.4243 f(s) 6061-T6 Bar .178" x 4.0" Material: 6061-T6 (QQ-A-250/11)4.00" x 0.188" thick Batch No. _____		
2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW Cut blanks: 6.200" 2 parts per blank		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio FA025 Tumble and deburr any rough edges after tumbling		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 13/12/2006 9:54:33 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 29352

Part Number: D2945

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



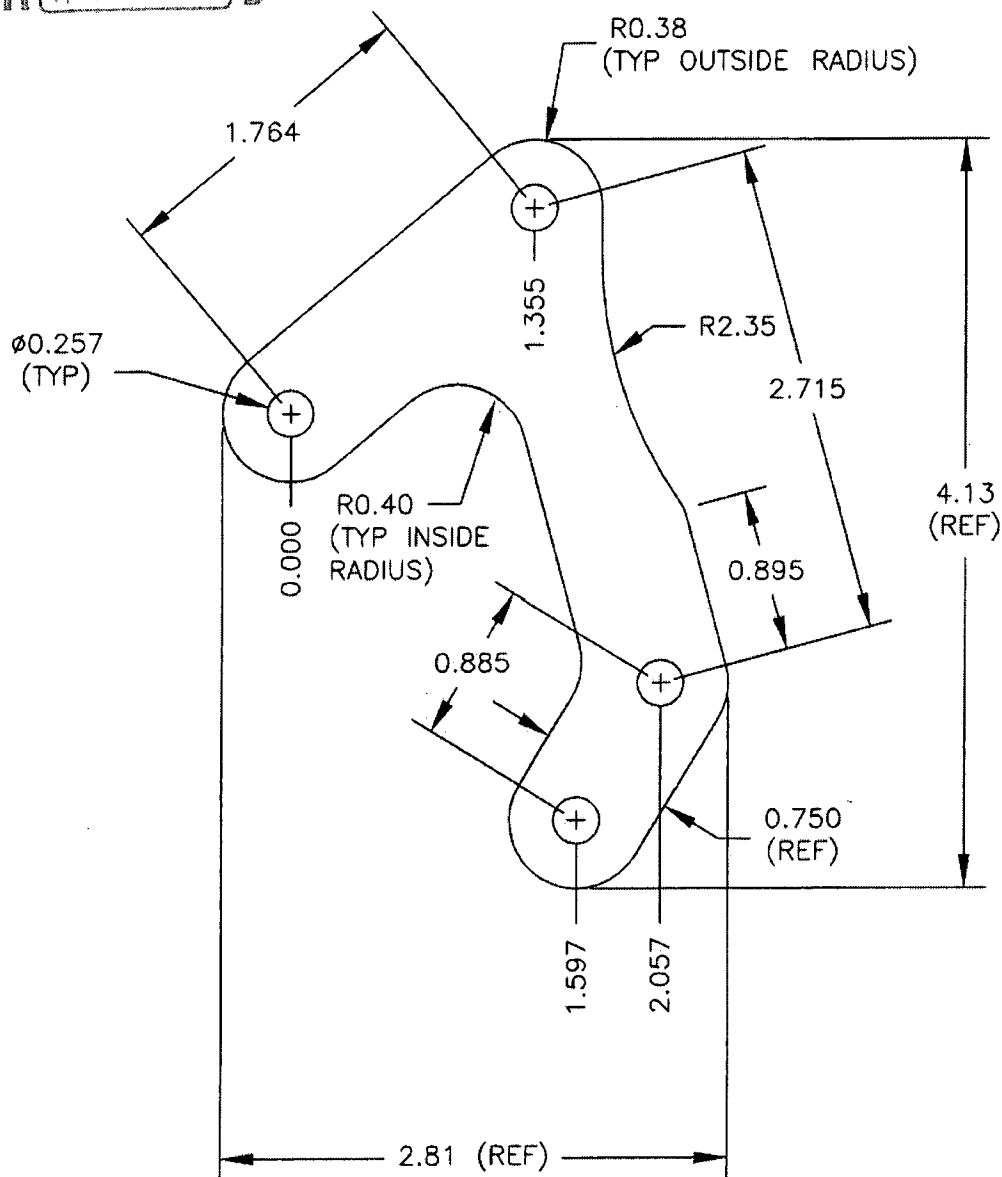
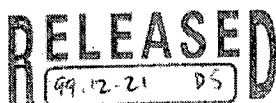
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29352

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES.